

1. A container for liquids, comprising:

a bottle, comprising:

a bottle body having a base and at least one sidewall
defining an interior reservoir for receiving and storing liquids,

5 a neck extending from an upper end of said sidewall,
opposite said base, and having a top edge defining an opening in
communication with said reservoir, and

external screw threads disposed on said neck; and

a closure configured to form a leak-proof seal and to be
10 removably received on said bottle body, proximate said opening, said
closure comprising:

an end wall having a peripheral edge and an interior
side,

at least one sidewall extending generally perpendicularly
15 from said end wall and circumscribing said peripheral edge,

internal screw threads disposed on said sidewall and
configured to engage said external screw threads disposed on said neck of
said bottle,

a seal ring disposed on said interior side of said end
20 wall,

a lobe disposed on said end wall and extending in a
direction opposite said sidewall and generally perpendicular to said end
wall, and

an aperture through said lobe.

2. The container of claim 1, wherein said bottle comprises polycarbonate.
3. The container of claim 1, wherein an exterior surface of said bottle body includes contours configured to facilitate grasping of the bottle by a user.
4. The container of claim 1, wherein said external screw threads disposed on said neck are spaced from said top edge of said neck a distance that facilitates uninterrupted engagement of said neck with the lips of a user.
5. The container of claim 4, wherein the uppermost external screw thread is spaced at least approximately 6 mm from said top edge of said neck.
6. The container of claim 1, wherein said opening of said bottle is sized to permit the unobstructed receipt of ice cubes into said reservoir through said opening.
7. The container of claim 6, wherein said opening is circular in shape and has an inner diameter of approximately 53 mm.
8. The container of claim 1, wherein said bottle body is at least semitransparent and further includes graduations disposed along said sidewall to indicate a volume of liquid disposed within said reservoir.

9. The container of claim 1, wherein said aperture is offset from the center of said closure, toward said peripheral edge of said end wall.

10. The container of claim 1, wherein said closure comprises at least two polymeric materials, a first inner one of said polymeric materials providing structural rigidity to said closure, a second outer one of said polymeric materials providing an aesthetic feel to said closure.

11. The container of claim 1, wherein said closure is formed from at least two polymeric materials, a first inner one of said polymeric materials having a durometer greater than a second outer one of said polymeric materials, whereby said first polymeric material provides structural strength to said closure and said second polymeric material provides an aesthetic feel to said closure.

12. The container of claim 10, wherein said first polymeric material is selected from one of polypropylene and high density polyethylene.

13. The container of claim 10, wherein said second polymeric material is selected from: thermoplastic elastomer, rubber, and a blend of thermoplastic elastomer and rubber.

14. The container of claim 10, wherein said closure is formed such that said second polymeric material generally encases said first polymeric material.

15. The container of claim 10, wherein an area proximate said aperture is substantially free from said second polymeric material.

16. The container of claim 10, wherein said closure is formed from three polymeric materials.

17. The container of claim 16, wherein said first, second, and third polymeric materials are polypropylene copolymer, polypropylene, and thermoplastic elastomer, respectively.

18. The container of claim 16, wherein an area proximate said aperture is substantially free from said third polymeric material.

19. A closure for a bottle, comprising:
an end wall having a peripheral edge and an interior side;
at least one sidewall extending generally perpendicularly from said end wall and circumscribing said peripheral edge;

5 a seal ring disposed on said interior side of said end wall;
a lobe disposed on said end wall and extending in a direction opposite said sidewall and generally perpendicular to said end wall; and
an aperture through said lobe;

said closure formed from at least two polymeric materials,
10 whereby said first polymeric material provides structural strength to said closure
and said second polymeric material provides an aesthetic feel to said closure.

20. The closure of claim 19, wherein said first polymeric material has a durometer greater than said second polymeric material.
21. The closure of claim 19, wherein said first polymeric material is polypropylene.
22. The closure of claim 19, wherein said second polymeric material is thermoplastic elastomer.
23. The closure of claim 19, wherein said closure is formed such that said second polymeric material generally encases said first polymeric material.
24. The closure of claim 23, wherein an area proximate said aperture is substantially free from said second polymeric material.
25. The closure of claim 19, further comprising external screw threads disposed on side sidewall.
26. The closure of claim 19, wherein said aperture is offset from the center of said closure, toward said peripheral edge of said endwall.
27. The closure of claim 19, wherein said closure is formed from three polymeric materials, said first polymeric material forming a core of said closure, said second polymeric material forming an intermediate layer of said closure, and said third polymeric material forming an outer layer of said closure.

28. The closure of claim 27, wherein said core of said first polymeric material is formed with a number of ribs and intervening voids to provide said core with areas of varying thickness, and said first polymeric material fills in said voids and forms said intermediate layer.

29. The closure of claim 27, wherein said first, second, and third polymeric materials are polypropylene copolymer, polypropylene, and thermoplastic elastomer, respectively

30. A method of forming an injection-molded leak-proof closure having multiple layers of materials and variable thickness comprising:

injecting a first material to form a seal ring and a core structure having raised ribs or ridges and intervening voids to form the general shape of
5 said closure; and

injecting a second material to fill in the voids and to provide a substantially uniform surface over the first material.

31. The method of claim 30, further comprising:

injecting at least a third material to cover at least a part of the second material.